

Date: Thursday, 3/23/2006 3:44:51 PM
 User: Kim Johnston

Process Sheet

SLIP

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FLOOR PROTCTOR AFT LH		
Job Number	: 26355			Part Number	: D32813		
Estimate Number	: 11228			Drawing Number	: D3281 REV B		
P.O. Number	: N/A			Project Number	: N/A		
This Issue	: 3/23/2006 S.O. No. : N/A			Drawing Revision	: B		
Prsht Rev.	: NC			Material	: N/A		
First Issue	: N/A Type : PURCHASED PARTS			Due Date	: 4/10/2006 Qty: 20 Um: Each		
Previous Run	: 25122						
Written By	: <i>SEE AA COMMENT Below</i>						
Checked & Approved By	: <i>AA 06.03.24</i>						
Comment	: Est Rev:A 04.07.01 New issue KJ/JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: <i>0000889</i> AFT <i>AK delastek</i> Description: Floor Protector LH Possible Supplier: Delastek Certificate of Conformity is required	
2.0	D32813P	Floor Protector, Aft LH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Floor Protector, LH	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure certificate of conformity is attached	
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.	<i>(19)</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>Relay/18</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/04/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/23/2006 3:44:51 PM
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Drawing Name: FLOOR PROTCTOR AFT LH

Job Number: 26355

Part Number: D32813

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

19

19 06/04/06

Job Completion



U 06-04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

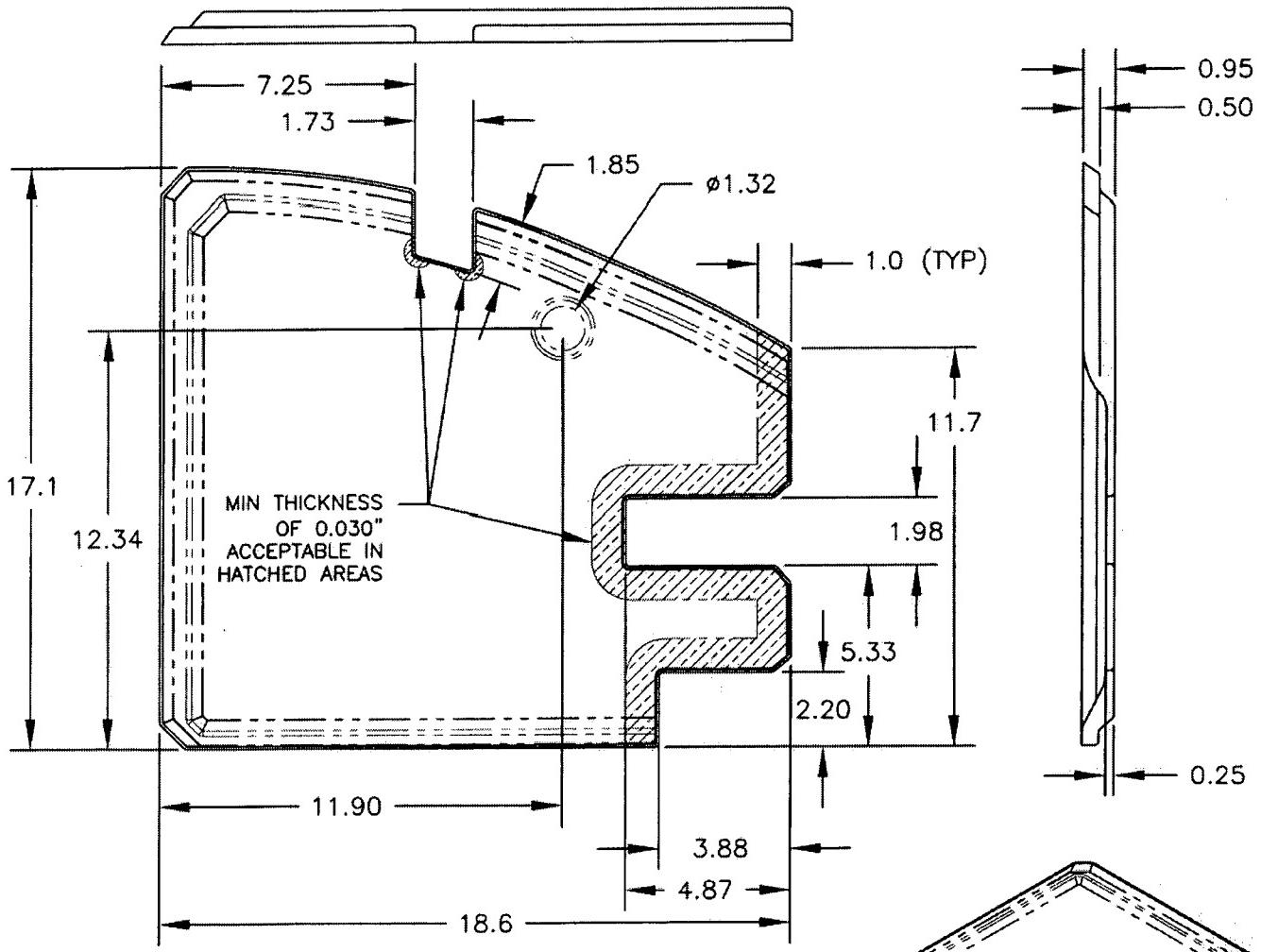
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>DP</i>	DRAWN BY <i>DP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	

**RELEASED**
05.12.01**D3281-1 FLOOR PROTECTOR, FWD LH**

- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

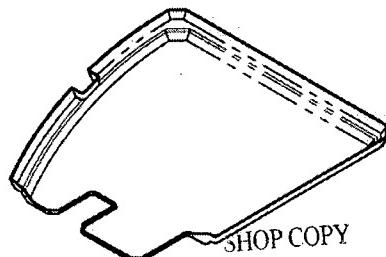
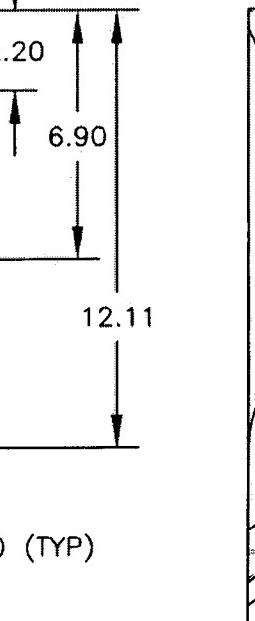
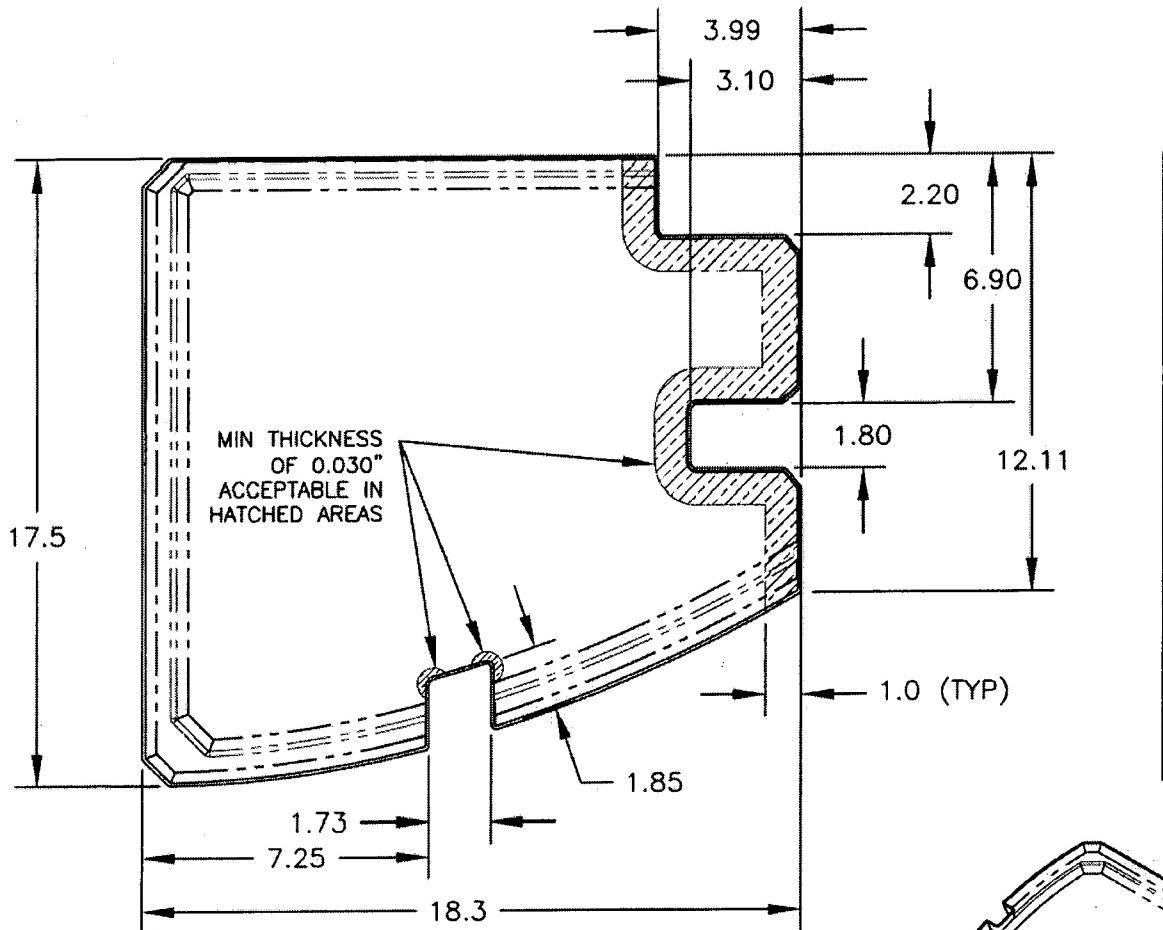
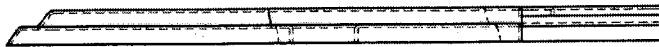
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *26355*

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DESIGN <i>DP</i>	DRAWN BY <i>DP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B	SHEET 2 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5	

**RELEASED**
05.12.01 *[Signature]***D3281-2 FLOOR PROTECTOR. FWD RH**

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

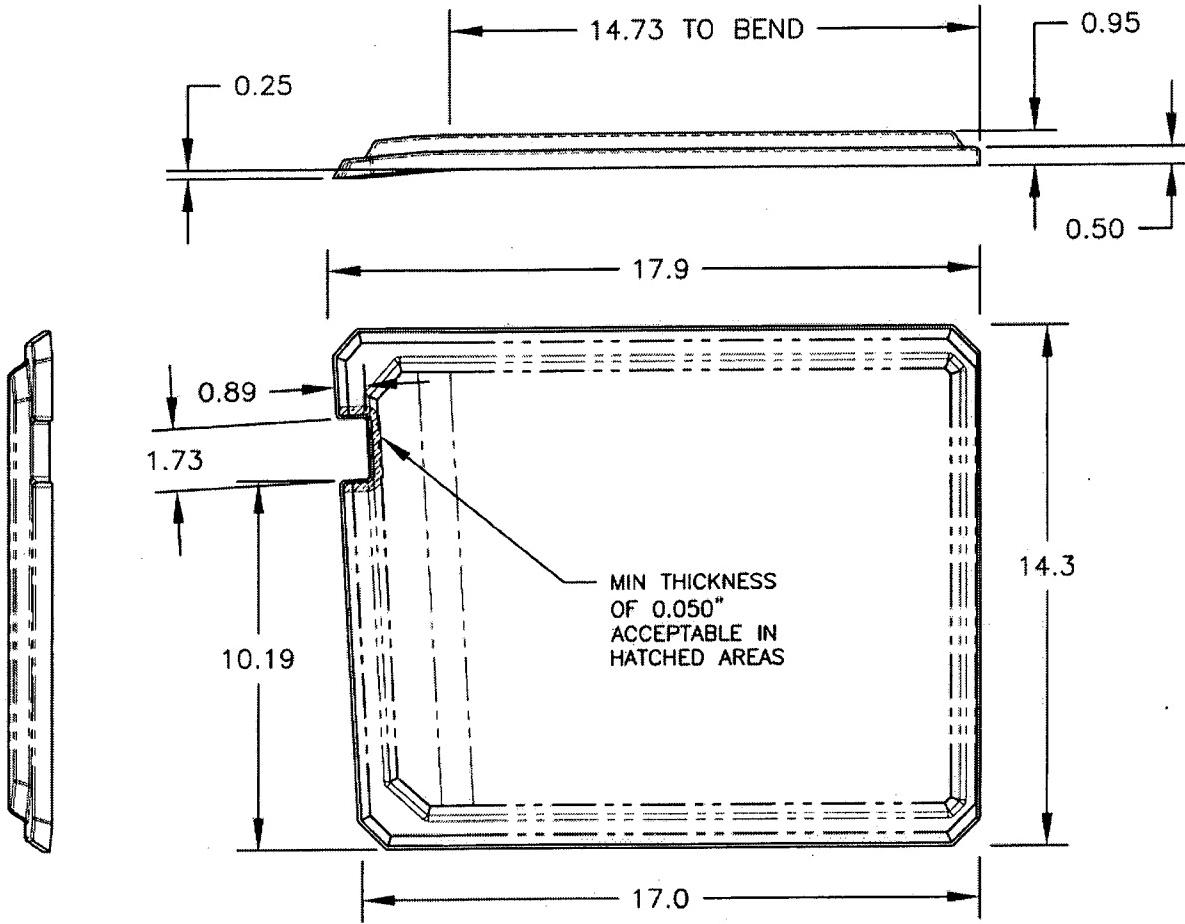
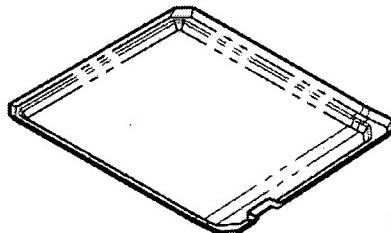
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B	SHEET 3 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE	1:5

**RELEASED**
05.12.01**D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)****D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)**

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2 UNCONTROLLED COPY
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2 SUBJECT TO AMENDMENT
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

SHOP COPY

RETURN TO

ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *06355*

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Feuille de Procédé

Client	:	DART	Dart Aerospace Ltd.	Nom Dessin	:	FLOOR PROTECTOR AFT, LH
Numéro Job	:	34175		Numéro Article	:	DKC134-0046
Numéro Soumission	:	2385		Numéro Dessin	:	D3281
Numéro B.A.	:			Projet Numéro	:	DKC134
Cette fois	:	2006-03-30	No. B.V. :	Révision dessin	:	B
Prsht Rev.	:	NC		Matériel	:	F6006
Prem. fois	:	--	Type :	Date Dûe	:	2006-04-07
Job précédente	:	32265		Qté:	20	UdM: UNITE
Écrit par	:					
Vérifié & Approuvé par	:					
Commentaires	:	N° de pièce: D3281-3 Process Sheet Rév.: 00				

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	APL0016	Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.
	Commentair Qty.: 0.167 UNITE(s)/Unit Total : Lexan F6006 Noir N° 700 48" x 96" x .125"	APL0016 Lexan F6006 Noir N° 700 48" x 96" x .125" Thk. # Bon achat: 5327
	N° de Lot: _____	
2.0	SÉCHAGE/ANEAL	

Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.6667Hrs
SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.

Inscrire sur la charte de température le numéro de Job du matériel au séchage.

de cuisson: 45920

3.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 60.0000Hrs
TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.



Quantité: 26 Date: 7/4/06 Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR AFT, LH

Numéro Job: 34175

Numéro Article: DKC134-0046

Numéro Job:



Séq.: Machine ou Opération:

Description :

4.0 THERMOFORMAGE2

THERMOFORMAGE DES PIÈCE DART



Commentair Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs

THERMOFORMAGE DES PIECES

Faire le thermoformage du "Floor Protector" N° D3281-3 à l'aide du moule N° D3281-3T1 sur le thermoformeur 4' x 8'.

Autocontrôle du lot de pièce thermoformées.

Quantité: 20 Date: 7-4-06 Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

5.0 TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs

TRIMAGE PLASTIQUE DART

Faire le trimage du "Floor Protector" N° D3281-3 à l'aide du gabarit de trimage N° D3281-3T2.

F-0-10-00706
DE
CO
M
P
T
E
C
-3

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 20 Date: 11-4-06 Sceau: J.C.

Quantité: _____ Date: _____ Sceau: _____

6.0 INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs

INSPECTION PIÈCE DART

*1 rejet : plastique
marqué*

Faire l'inspection finale des pièces selon le dessin.



7.0 IDENTIFICATION4

IDENTIFICATION PIÈCES DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs

IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 34175

Nom Dessin: FLOOR PROTECTOR AFT, LH
Numéro Article: DKC134-0046

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
	N° de pièce: D3281-3 N° de Job: _____ Date de fabrication: _____ Sceau d'inspection.	Quantité: <u>20</u> Date: <u>11-04-06</u> Sceau:
	Quantité: _____ Date: _____ Sceau: _____	

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs

EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton identifiée comme suit:

N° de pièce: D3281-3
Date de fabrication: _____
N° de job: _____

Quantité: 20 Date: 12/4/06 Sceau:

Quantité: _____ Date: _____ Sceau: _____